

Date: Tuesday, 10/02/2009 11:09:23 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER	
Job Number :	45676			
Estimate Number :	13581			
P.O. Number :		Part Number :	D38163	
This Issue :	10/02/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3816 REV A	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	42078	Drawing Revision :	A	
Written By :		Material :		
Checked & Approved By :	JUD 09-02-10	Due Date :	20/02/2009	Qty: 20 Um: Each
Comment :	Est Rev:A New Issue 08-09-17 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0326 f(s)/Unit Total: 0.6510 f(s) + 1 ft end
 6061-T6 Round Bar .500"
 Batch: M109 396

09/02/13

20 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE Lathe

1- Turn as per Folio FA785 Rev: AA & Dwg D3816 Rev: A

2-Deburr per dwg D3816

09/02/13

20 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/02/13

20 pcs

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/02/17 (CO)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:23 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 45676

Part Number: D38163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Handwritten signature



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-17

(20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

169/2/18 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-18

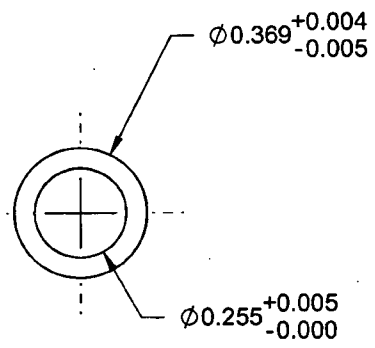
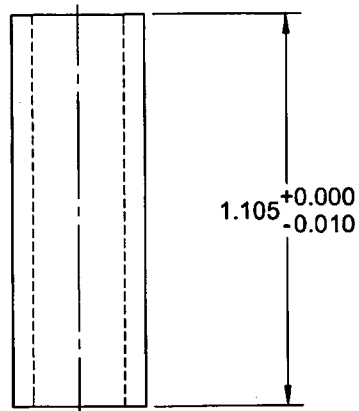
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

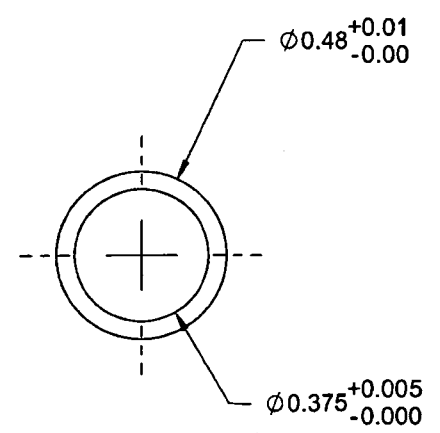
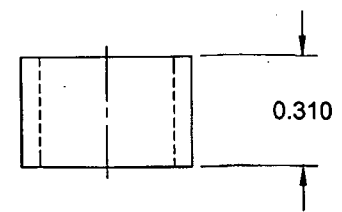
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

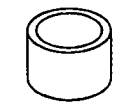
NOTE: Date & initial all entries



D3816-1 SPACER



D3816-3 SPACER



- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

A	NEW ISSUE	BY	08.09.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3816	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	08.09.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED
09/01/13